Work Order ID 56562

Quality Control

Monday, March 01, 2010 2:54:49 PM



Page 1

Item ID: D3815-041 Accept Setup Start Revision ID: Stop Item Name: Web Assembly Start Qty: 12.00 Start Date: 3/2/2010 Cust Item ID: Required Date: 3/15/2010 Req'd Qty: 12.00 Customer: Reference: Run Start Process Plan: MF Date: 10-3-1 Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Reject Draw Plan Accept Reject Insp. Work Center ID Description Run Hours Number Rev. Code Qty Qty Number Stamp Draw Nbr Revision Nbr D3815 Rev A 100 Pick Kit 0.00 Packaging 0.00 Memo Packaging 110 0.00 Small Fab Small Fab 0.00 Memo Small Fab 1- install rivets as per dwg D3815 120 QC5- Inspect part completeness to step on W/O Memo

Dart Aerospa	ace	_td
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W/O:			WO	RK ORDER CHANG	ES				a) T
DATE	STEP	PR	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	DAD #-	Fault Cates	ion.	NCP: Voc	No. DO		Deter	
raitivo		PAR #: esolution:							
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCR)			
DATE	CTED	Description of NC Corrective Action			on B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
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Work Order ID 56562

Monday, March 01, 2010 2:54:49 PM



Page 2

Item ID:

D3815-041

Accept

Setup Start



Revision ID:

Item Name: Web Assembly

Start Date:

Reference:

3/2/2010

QC:

Start Qty: 12.00

Required Date: 3/15/2010

Reg'd Oty: 12.00



Cust Item ID: Customer:

Run

Start

Stop



Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Draw

Number

Date: Date:

Draw

Rev.

Plan

Code

Stop

Reject

Qty

Number Stamp

Insp.

Sequence ID/

Work Center ID

130

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M113170

Memo

STARTTIME: 2:30 DM OVEN TEMPERATURE: 370 FINISH TIME: 3:00

Set Up/ Run Hours

0.00 > M 10/03/17

Qty

Accept

Reject

140

Quality Control

QC3- Inspect Part Finish

Memo

De 10-3-17

150

Small Fab

Small Fab

Small Fab

0.00

0.00

1- install screws loose (4 places) as per dwg D3815

Dart	Aer	ospace	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:	
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NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCF	R)			
DATE	CTED	Description of NC	ion B	Verific	ation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
									219
									1
								1	

Work Order ID 56562

Monday, March 01, 2010 2:54:49 PM



Page 3

Item ID:

D3815-041

Accept

Setup Start



Revision ID:

Item Name: Web Assembly

Start Date:

3/2/2010

Start Qty: 12.00

Required Date: 3/15/2010

Req'd Qty: 12.00



Cust Item ID: Customer:

Reference:

Approvals: Process Plan:

QC:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Stop

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/ Run Hours

Siolos 18

Draw Number

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

170

180

Packaging

Quality Control

Packaging

Identify as per dwg & Stock Location:



0.00 0.00

Memo

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

W/O:		50 m354	WC	DE ODDED CHANG	200					
			WC	ORK ORDER CHANG	JE5				Approval	
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Chief Eng / Prod Mgr	Approval QC Inspector
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										1
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Part No		PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ	A:	Date:	
		olution:								
NCR:			WORK ORDE	ER NON-CONFORM	ANCE	(NCR)				,1
		Description of NC	Corrective Action Sec	ction B	Verific	eation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti		Chief Eng	QC Inspector
										1 1 1 1 1
										- 1

Picklist Print

Monday, March 01, 2010 2:54:48 PM

Work Order ID: 56562

Parent Item: D3815-041

Parent Item Name: Web Assembly

Comments:

IPP Rev:A 08-09-18 new issue DD verified by:EC



Start Date: 3/2/2010

Required Date: 3/15/2010

Component Item ID/	Replacement	Mfg/	Dim	Dut	• 1100000				Start Qty: 12.00	1	Required Qty: 1	2.00
Item Name	Item ID	Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
03815-1		Manufactured	No			110	Each	0.0000	12,0000	2		
ingle						73	5677	6 (12)		50/03	16	
3815-2		Manufactured	No			110	Each	2.0000	12,0000			
ngle										25/01	62/16	
				Warehou	ise	Loc C	<u>Oty</u>	Loc Code	7		7	
				Loca					7	35677	FIOX	
				Main Wa	rehouse		2					
815-3		V	N. P.		53896		2			2		
		Manufactured	No			110	Each	7.0000	12.0000	21	11	
eb										\$101	03/16	
				Warehou Locat		Loc Q	<u>oty</u>	Loc Code				
				Main War						B50	778 (500
				ST			7					
320470AD4-6		Purchased	No		52928	110	7 Fact	2 (70 000		7		
						110	Each	2,670.000	300,0000	12 los	lu lu	
et, Universal Head				***					9	p/0/03	116	
				Warehous Locat		Loc Qu	t <u>v</u> <u>j</u>	Loc Code	/			
				Main Ward								
				ST	westy		70					
					13644	26	70		2	300		

Page 1

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval Approval DATE STEP PROCEDURE CHANGE By Date Qtv Chief Eng / Prod Mgr QC Inspector Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) NCR:

	2200	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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						* * ·		
		The state of the s			,			1

Picklist Print

Monday, March 01, 2010 2:54:49 PM

Page 2

Work Order ID: 56562

Parent Item: D3815-041

Parent Item Name: Web Assembly

Comments: IPP Rev:A 08-09-18 new issue DD verified by:EC

Purchased



Start Date: 3/2/2010

Required Date: 3/15/2010

Start Oty 12 00

Component Item ID/	Replacement	Ment	n.	Trans					Start Qty: 12.00	,	Required Qty: 12.00		
Item Name	Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty	Date	Status	
AN526C832R14		R14	Durchassal	NI.						Qty 10 Fick	Issued	Issued	
	######################################	Purchased	No			150	Each	879.0000	48.0000				

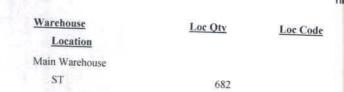
Screw

Warehouse Loc Qty Loc Code Location Main Warehouse

ST 879 104916 879 150

Each 682.0000 48.0000

MS21042L08 Nut



24

111889 30 112243 43 112492 24 112612 112794 113595 29 113749 323 114056 200

110002

Dart	Aeros	pace	Ltd
	,,0,00	2000	

	. oopaoo								
W/O:			W	ORK ORDER CHANG	iES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
	Re	esolution:						Date: _	
NCR:			WORK ORE	DER NON-CONFORM	ANCE (NO	R)			
DATE	STEP	Description of NC		Corrective Action Sect	Approval	Approval			
DATE	SIEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign Dat	& Sec	cation tion C	Chief Eng	QC Inspector
	1		T I					I .	

Picklist Print

Monday, March 01, 2010 2:54:49 PM

Work Order ID: 56562

Parent Item:

D3815-041

Parent Item Name:

Web Assembly

Comments:

IPP Rev:A 08-09-18 new issue DD verified by:EC

Start Date: 3/2/2010 Start Qty: 12.00

Required Date: 3/15/2010

Required Qty: 12.00

Component	Item	ID/
Item Name		

Replacement Mfg/ Item ID Purch

Bin Primary Item Location

Last Location

111359

114056

Route Seq ID

30

100

Unit of Measure

Qty on Hand

Remaining Qty Qty To Pick Issued

Status

Page 3

NAS1149DN832J

Purchased

No

150

Each 133.0000

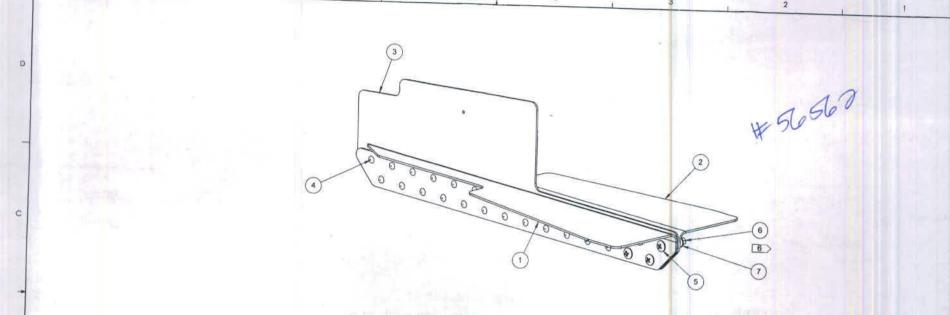
48,0000

Date Issued

WASHER

Warehouse	Loc Qty	Loc Code
Location		Loc Code
Main Warehouse		
ST	133	
111193	3	

	The second secon										
W/O:			WC	RK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	•/	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:			
Resolution:			Disposition	Disposition: QA: N/C Clo				osed: Date:			
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)			5		
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval Chief Eng	Approval		
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti			QC Inspector		
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3815-1	ANGLE	-041
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	1
5	AN526C832R14	SCREW	25
6	MS21042L08	NUT	4
7	NAS1149DN832J		4
	The state of the s	WASHER	4

D3815-041 WEB ASSEMBLY

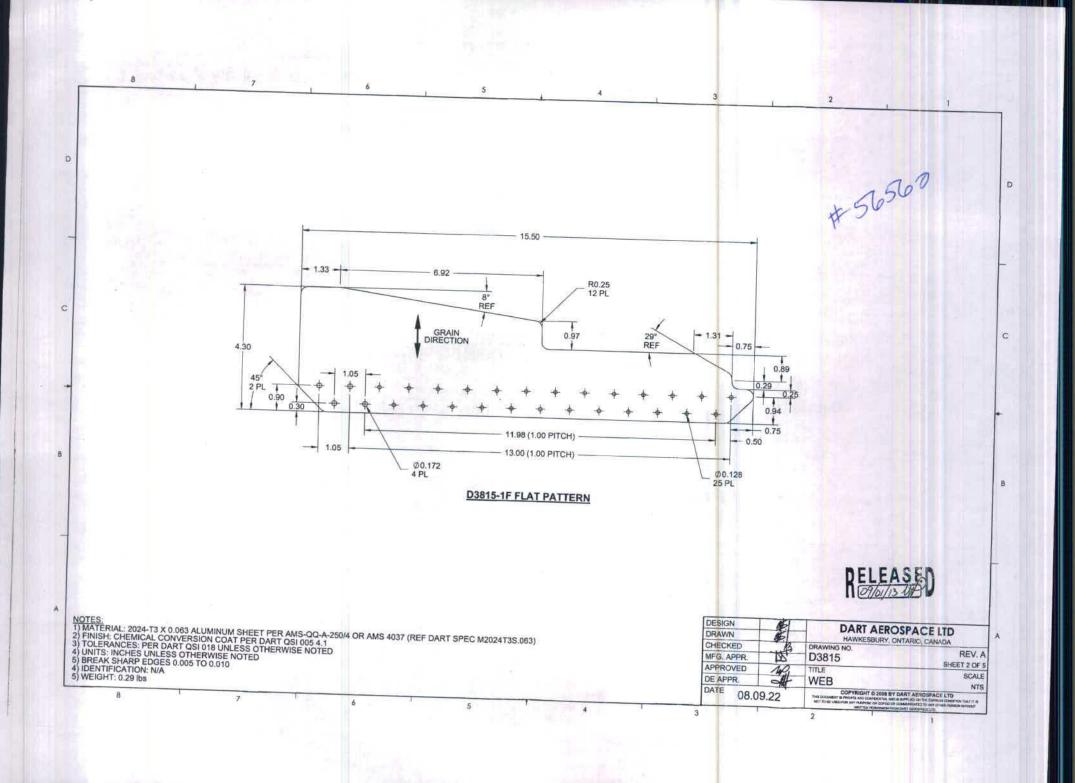
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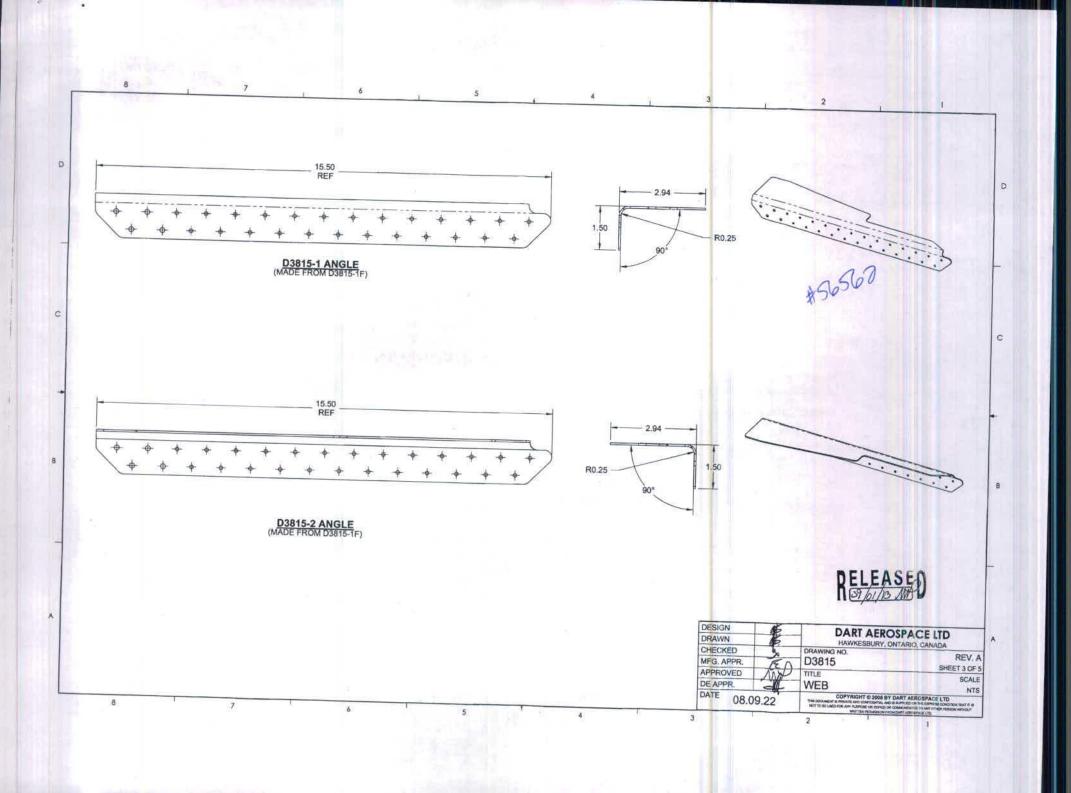
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REV.		-	DESCRIPTION DART AERO HAWKESBURY, O DRAWING NO. D3815	1	08.09.22
DESIG	N.	-		8Y	DATE
DRAW	V		DART AER	OSPACE LI	D
CHECKED		K	DRAWING NO.	CHIPPIO, CAPAL	
MFG. A	PPR.	150	D3815		REV. A
APPRO	VED	MAD	TITLE	- 3	SHEET 1 OF 5
DE APE	OD.	V	The state of the s		SCALE
	-	TA CA	VVLD		NTS
DE APP	08.0	9.22	WEB COPYRIGHT © 2008 B THE DOCUMENT OF HONDING MOT TO STUBBLE FOR ANY PURPOSE OF COMPANY OF THE DOCUMENT OF THE PURPOSE OF COMPANY MOT TO STUBBLE FOR ANY PURPOSE OF COMPANY OF THE PURPOSE OF THE PURPOSE OF THE PURPOSE THE PURPOSE OF THE PURP	BY DART ALROSPACE	LTD

NOTES:
1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
3) UNITS: INCHES UNLESS OTHERWISE NOTED
4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
5) WEIGHT: 0.88 lbs
6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

W/O:			WC	ORK ORDER CHANG	iES						
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQA:	Date:			
						QA: N/C Closed: Date:					
NCR:		- 1	WORK ORDI	ER NON-CONFORM	ANCE (N	CR)					
DATE	CTED	Description of NC			tion B	Ve	rification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng			Section C	Chief Eng	QC Inspector		
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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CHAP	IGE	В	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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Resolution:			Disposition: QA: N/C Closed: Da						Date:	
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DATE	STEP Description of NO Section A	Description of NC	Corrective Action Section B			VA		ation	Approval	Approval
DATE			Initial Chief Eng	Action Description Chief Eng	Si	gn & ate	Section C		Chief Eng	QC Inspecto
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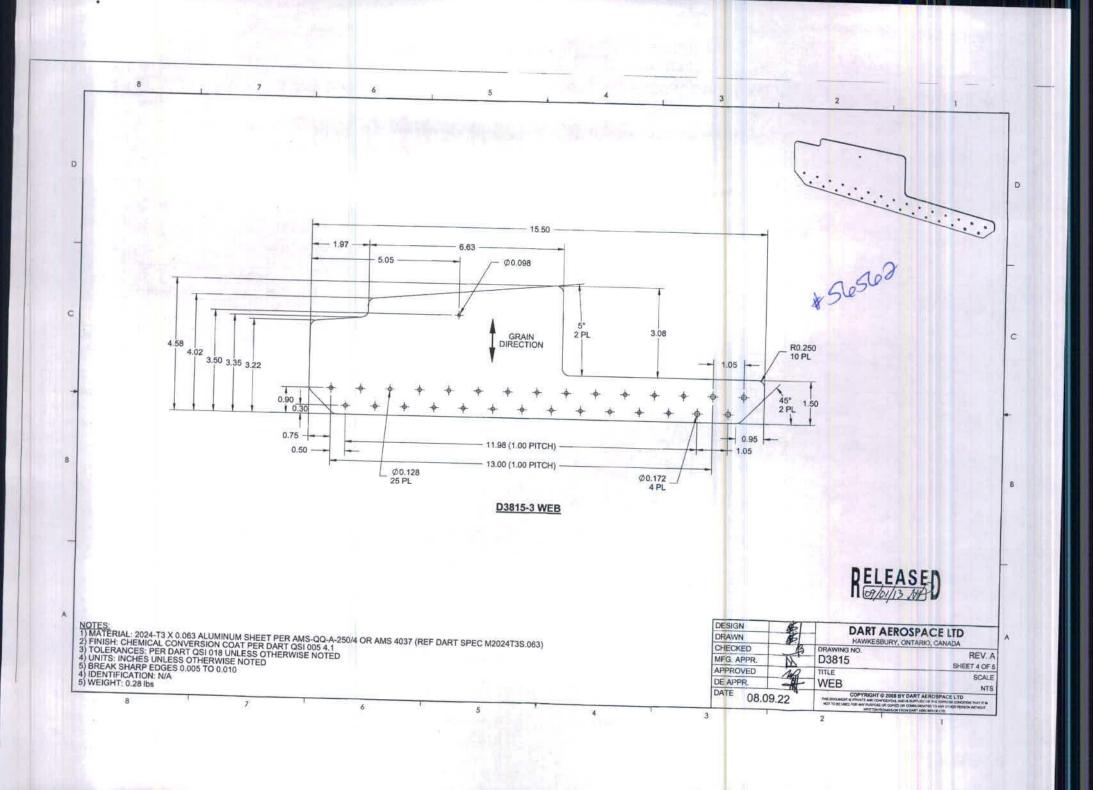


Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr

Approval QC Inspector

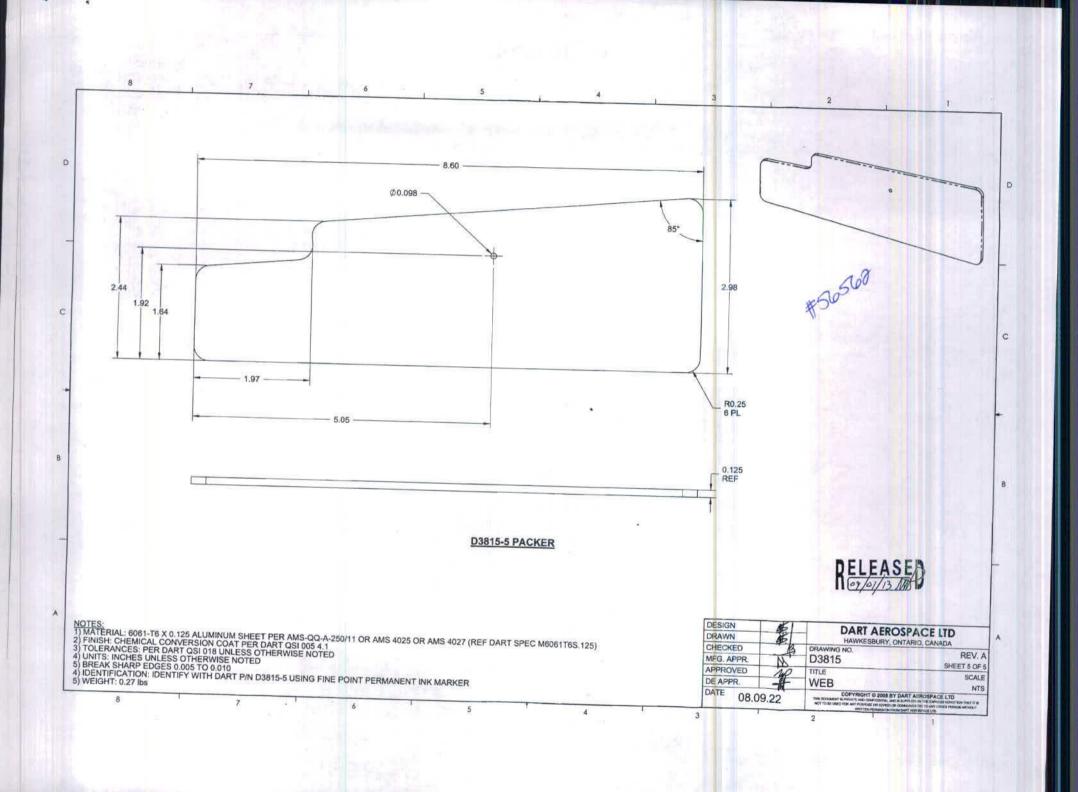
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Dart	Aerospac	e Ltd
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W/O:			WO	RK ORDER CHANG	ES				
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DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval Chief Eng	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	escription Sign &	Secti			QC Inspector
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Dart Aerospace Ltd W/O: WORK ORDER CHANGES Approval Approval STEP DATE PROCEDURE CHANGE By Qtv Date Chief Eng / QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ____ Resolution: _____ Disposition: ____ QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) NCR: Corrective Action Section B Description of NC Verification Approval Approval DATE STEP **Action Description** Sign & Initial Section A QC Inspector Section C Chief Eng Chief Eng Date Chief Eng